

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 01.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000187**Date Inspected:** 01-Jun-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Benicia, CA**CWI Name:** Michael Johnson**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Procedure Qualification Record (PQR) Test**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Mary Madere is present at the Ironworkers Apprenticeship Training Facility as requested by ABF for the continuing purpose of witnessing Procedure Qualification Record tests. On this date, the QA Inspector observed the following personnel present: Smith-Emery Company's Quality Control (QC) Representative Certified Welding Inspector (CWI) Mr. Michael Johnson, ABF Representatives Mr. Tommy Gibson and Mr. Rick Clayborn and welder Mr. Dan Gordon.

**Procedure Qualification Record (PQR) Summary:**

Since the beginning of PQR testing on March 26, 2007, ABF has attempted twenty-four (24) PQR test plates. As of this date, six of the twenty four test plates have passed radiographic testing (RT). However, one of the six test plates that has passed RT was not visually accepted by Caltrans due to a twenty percent variation in travel speed, which exceeds the requirements of the Special Provisions. See summary of conversations below for additional information.

On this date, the QA Inspector observed Davis Laboratories, Incorporated personnel in the process of performing radiographic testing (RT) on three procedure qualification record (PQR) test plates identified as ABF-PQR-016-1B, ABF-PQR-020-2 and ABF-PQR-020-1. The QA Inspector observed Davis Laboratories Representative Mr. Matt Schonhoff as he set up his equipment in accordance with the requirements of AWS D1.5 2002, Section 6.10. At the completion of testing, Mr. Schonhoff informed the QA Inspector that the three PQR plates tested on this date are acceptable.

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## WELDING INSPECTION REPORT

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### Summary of Conversations:

ABF Representative Mr. Tommy Gibson informed the QA Inspector that he directed his welder to increase his travel speed for the root pass only on the third attempt of the PQR test plate identified as ABF-PQR-016-1. In addition, Mr. Gibson stated that the test plate was intentionally welded outside of the requirements of the Special Provisions in an effort to prove to Caltrans that these guidelines are not practical for use in the field. Mr. Gibson then stated that ABF was in the process of generating a Request for Information (RFI) which will compare the successful RT results of the PQR plate in question and the unsuccessful RT results of previously tested and failed PQR attempts where the requirements of the Special Provisions were fulfilled. Mr. Gibson stated that the RFI should be completed and ready to submit to Caltrans by the end of the following week.

On May 30, 2007, ABF was informed by Caltrans QA Inspector Mr. Gregory Bertlesman that Caltrans is not going to accept this PQR test plate due to a twenty percent variation in travel speed between the root pass and the subsequent weld passes.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Madere,Mary	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer

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